

		M	
STC SH7923SW	STC SH7934SW		

8 7 6 5 4 3 2 1

NOTES CONTINUED FROM SHEET 1 ZONE 6C

- F) REPEAT STEPS (C) THRU (E) UNTIL THE REQUIRED CLEARANCE IS OBTAINED.
- G) ¹⁵¹⁸ REMOVE QUILL ASSY FROM THE TRANSMISSION (REF. NOTE 8D/E) AND INSTALL M83248/1-248 O-RING, MIL-S-8802 SEALANT AND MASTINOX 685K CORROSION PREVENTIVE COMPOUND ON THE TRANSMISSION AND/OR QUILL ASSY PER DRAWING INSTRUCTIONS.
- H) REINSERT THE QUILL ASSY INTO THE TRANSMISSION AND COMPLETE ALL OTHER QUILL INSTALLATION OPERATIONS. (SEE SHEET 2 FOR -01 & -39 INSTALLATION)
- I) INSTALL BRACKET P/N 205-040-114-001 AS PER INSTALLATION VIEW A-A SHEET 2A ZONE 2B.
- J) FOLLOWING INSTALLATION OF THE 212-040-703 (-39) & 412-040-703 (-01) QUILL ASSY, REF., CONFIRM THE EXISTENCE OF BACKLASH BETWEEN THE 212-040-702 (-39) & 412-030-310 (-01) PINION AND THE 204-040-701 (-39) & 412-040-701 (-01) GEAR WITHIN THE TRANSMISSION BY ROTATING (ROCKING) THE PIN BACK AND FORTH BY MEANS OF ITS SPLINED OUTPUT SHAFT IN THE LOWER ACCESSORY DRIVE PAD. THE AMOUNT OF BACKLASH NEED NOT BE MEASURED.

- ¹⁰ INSTALL -21 TROUGH REF. AS FOLLOWS:
- A) CUT AND REMOVE EXISTING TROUGH PER DIMENSIONS SHOWN.
- B) PRO-SEAL AND TACK -03, -05, AND -07 NUTPLATE STRIP ASSY. ONTO EXISTING TROUGH EDGE AS SHOWN.
- C) MATCH DRILL -21 TROUGH TO (INSTALLED) -03, -05, AND -07 ASSY. 31 PLACES.
- D) INSTALL -37 ASSY USING MS27039-1-08 SCREWS & AN960PD10L WASHER (5 PL) AND VIEW C-C WHEN APPLICABLE.
- E) ATTACH -21 TROUGH TO ACFT USING AW52510R8 SCREW 31 PL. REF.
- F) APPLY AB 890 PROSEAL TO PLATENUTS ON -03, -05, & -07 ASSY AND EDGES OF MODIFICATION TO PREVENT MOISTURE LEAKAGE.

- ¹¹ REF. WIRE DIAGRAM 400 AMP GENERATOR, B23-12000. (PREMIER)
- ¹² SAFETY WIRE PER MS33540 AS APPLICABLE.
- ¹³ BEFORE RIVETING ASSY, MUST BE PREFORMED TO GENERATOR! REINSTALL PROTECTIVE BACKING BEFORE INSTALLATION. CAUTION:: NO BURRS / SCREEN MUST NOT INTERFERE WITH INTERNALS OF GENERATOR!!

- ¹⁴ ¹⁵ PRIOR TO INSTALLATION OF SET SCREW: PREPARE SET SCREW AND THREADED HOLE IN CASE, APPLY A THIN COAT OF MIL-S-8802 SEALANT TO THE THREADED PORTION OF SET SCREW ONLY. NO SEALANT SHALL BE PRESENT ON POINT OF THE SET SCREW OR IN THREADED HOLE PRIOR TO INSTALLATION OF THE SET SCREW. AFTER INSTALLATION OF SET SCREW, INSURE THAT NO SEALANT IS PRESENT ON ADJACENT SURFACES OR IS PROTRUDING FROM THREADED HOLE.

- ¹⁵ DO NOT EXPOSE SEALANT-COATED PARTS TO OIL FOR 24 HOURS AFTER SEALANT HAS BEEN APPLIED IF CURED AT ROOM TEMPERATURE. CURING MAY BE EXPEDITED BY HEATING AT 120 DEGREES F +/- 10 DEGREES F FOR (8) HOURS. AFTER WHICH TIME PARTS MAY BE EXPOSED TO OIL.


- ¹⁶ INSTALLATION OF MS51964-97 SET SCREW ONLY APPLIES TO 212 SHIP SERIAL NUMBERS 30680 THRU 30939.

- ¹⁷ ¹⁸ APPLY A THIN EVEN FILM OF MASTINOX 685K CORROSION PREVENTIVE COMPOUND TO INDICATED AREAS OF THE TRANSMISSION QUILL PORT AND THE QUILL ASSEMBLY IMMEDIATELY PRIOR TO INSTALLATION OF THE QUILL. THIN COMPOUND AS REQUIRED WITH MEK TO OBTAIN A BRUSHABLE CONSISTENCY.

- ¹⁸ BEFORE APPLYING FRESH CORROSION PREVENTIVE COMPOUND IN ACCORDANCE WITH NOTE 17, THE BORE AND FACE OF THE TRANSMISSION ACCESSORY QUILL PORT MUST BE COMPLETELY CLEANED OF ANY SEALANT, PAINT, AND CORROSION PREVENTIVE COMPOUND RESIDUE.

- ¹⁹ ¹⁵ AFTER INSTALLATION OF QUILL ASSY., APPLY A SMALL BEAD OF MIL-S-8802 SEALANT AT THE TRANSMISSION TO QUILL INTERFACE.

- ²⁰ ¹⁵ AFTER ASSEMBLING QUILL ASSY. INTO TRANSMISSION ASSY., COAT SURFACE OF PLUG WITH MIL-S-8802 SEALANT. INSTALL PLUG AND APPLY A BEAD OF MIL-S-8802 SEALANT AROUND PROTRUDING O.D. OF PLUG.
- ²¹ CAUTION: THIS KIT MUST NOT BE INSTALLED IN 212-040-001 OR 412-040-002 TRANSMISSION ASSEMBLIES.
- ²² CAUTION: THE 412-040-703 QUILL ASSY. IS A LOOK-ALIKE PART. ENSURE THAT THE 412-040-310 GEAR HAS FOUR HOLES IN ITS WEB. AS SHOWN IN VIEW D-D SHEET 2A.
- ²³ AFTER COMPLETION OF QUILL INSTALLATION REPLACE DECAL AS SHOWN IN VIEW E SHEET 2A ZONE 5A.
- ²⁴ THE -41 SPLICE REF. IS FOR PREMIER HOIST INSTALLATION ONLY, AND IS NOT INSTALLED WITH STANDARD GENERATOR/PUMP QUILL INSTALLATION.

REF							REF	B23-13004-01	GENERATOR COOLING FAN INSTL.	PREMIER			
REF							REF	B23-13003	GENERATOR LINE ROUTING INSTALLATION	PREMIER			
REF							REF	B23-13002-75	STRAP	PREMIER			
REF							REF	B23-13001	MOD SYS 2 HYD PUMP INSTL	PREMIER			
REF							REF	B23-12000	WIRE DIAGRAM 400 AMP GEN.	PREMIER			
A/R							A/R	965073/3623-03	LABLE TAPE	GENERAL BINDING			
1								412-040-703-103	QUILL	BHT			
REF							REF	400SG1260-1	GENERATOR	AIRCRAFT PARTS CORP			
1							1	212-075-033-103	DECAL	BHT			
1							1	212-040-199-001	WASHER	BHT			
							1	212-040-703-105	QUILL	BHT			
1							1	205-040-114-001	BRACE	BHT			
A/R							A/R	120-038E24-13	SHIM	BHT			
A/R							A/R	100S	SILICONE TAPE 1.0 x .12 THK	CHR Industries			
REF							REF	T101338	JACKSCREW SET	BHT			
A/R							A/R	MIL-S-8802	SEALANT	BHT			
A/R							A/R	MASTINOX 685K	CORROSION PREVENTIVE COMPOUND	AMERICAN EUROCOPTER			
1							1	CR3243-4	RIVET	CHERRY			
				A/R	A/R	A/R		AB 890	PORSEAL	HYSOL			
4							4	NAS43HT6-25	SPACER				
1							1	M83248/1-248	O-RING				
2							2	M5501/7-F10	CAP				
1							1	MS913601	GASKET				
							1	MS51966-148	SET SCREW				
							1	MS51964-97	SET SCREW				
							1	MS29561-248	PACKING				
5							5	MS27039-1-08	SCREW				
1							1	MS25160	ADAPTER				
8	2	1		4	6	7	8	MS21075L3	NUTPLATE				
			1					MS21069L3	NUTPLATE				
1							1	MS21062L3	NUTPLATE				
12							12	MS21042L6	NUT				
A/R							A/R	MS20995N32	WIRE				
A/R							A/R	MS20995C32	WIRE				
A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	MS20426AD3	RIVET				
A/R							A/R	MS20426AD4	RIVET				
QTY PER	QTY PER	QTY PER	QTY PER	QTY PER	QTY PER	QTY PER	QTY PER	PART NO.	DESCRIPTION	SPECIFICATION	CODE IDENT NO.	ITEM NO.	
-39	-37	-15	-09	-07	-05	-03	-01	PARTS LIST					

NOTES CONTINUED ZONE 5D

SIZE	CODE IDENT NO.	REV.
D	OSUV8 B23-13002	G
GEN/PUMP QUILL INSTALLATION		SHEET 1A OF 5

STC SH7934SW
STC SH7923SW
2B2313002.1A
ORIGINAL

212-040-703-105 QUILL (-01)
412-040-703-103 QUILL (-39)

MS913601 GASKET
MS21042L6 NUT
AN960-616 WASHER
AN960PD616 WASHER

400SG1260-1 GENERATOR
B23-13003 LINE ROUTING

B23-13004-01 GENERATOR
COOLING FAN INSTL.
MS25160 ADAPTER
MS20995N32 WIRE
AN501-10-8 SCREW
AN960C10 WASHER

MS20426AD3 RIVET A/R
PICK-UP PILOT HOLE
PATTERN IN -03, TO
MOUNT -03 TO -21

MS20426AD3 26 PL
PICK-UP PILOT HOLE
PATTERN IN -05, TO
MOUNT -05 TO -21

100S SILICONE TAPE
1.0 X .12 THK.

EXISTING SKIN
REF.

NO. 10(.193) DIA HOLE THRU
-21 MATE FROM -03, -05,
-07 & -15 AN52510R8 SCREWS
31 REQD.

SYSTEM 2 HYDR PUMP
SEE DWG B23-13001 REF
FOR INSTALL

-43 BRACKET
REF.

120-038E24-13 2 REQD
ADJUST SHIM THICKNESS SUCH
THAT TOP SURFACE OF SHIM
IS COPLANER WITH TOP SURFACES
OF NAS SPACERS WITHIN .003

MS29561-248 PACKING
MS51966-148 SET SCREW
MS51964-97 SET SCREW

(RH)
(LH)

M5501/7-F10 CAP 2 PL

M83248/1-248 O-RING

AN6H34A BOLT
AN960JD616 WASHER
AN960-616 WASHER
TORQUE TO 160-190 IN-LBS
MS20995C32 LOCKWIRE

AN6H43A BOLT
AN960JD616 WASHER
AN960-616 WASHER
TORQUE TO 160-190 IN-LBS
MS20995C32 LOCKWIRE

BL
0.00
REF

EXISTING SKIN
REF

EXISTING SKIN
REF

DRILL -.37 TO MATE WITH
EXISTING HARDWARE. 9 PL
MS21075L3 NUTPLATE 8 PL
MS21062L3 NUTPLATE
MS20426AD3 RIVET 2 REQD. 9 PL

STIFFENER
REMOVE AND DISCARD
EXISTING STIFFENER

CR32/3-4 RIVET

CLIP
REMOVE AND DISCARD
EXISTING CLIP

REMOVE EXISTING SKIN .375
TO -17 REF. VERTICAL ANGLE EDGE
AND EXISTING HORIZONTAL ANGLE EDGE

MS20476AD4 RIVET
4 REQ'D.
APPROX.

TRIM -21 A/R TO
PICK-UP 6
FASTENERS

.375 4.30 REMOVE
REF

VIEW B-B

VIEW LKG FWD AT
STA 127.47 REF.
VIEW LESS QUILL
GENERATOR, HYD PUMP

-01 INSTALLATION (212, 412,
412 SP)

-39 INSTALLATION (412 HP)

SIZE	CODE IDENT NO.	REV
D	OSUV8 B23-13002	G
GEN/PUMP QUILL INSTALLATION		SHEET 2 OF 5

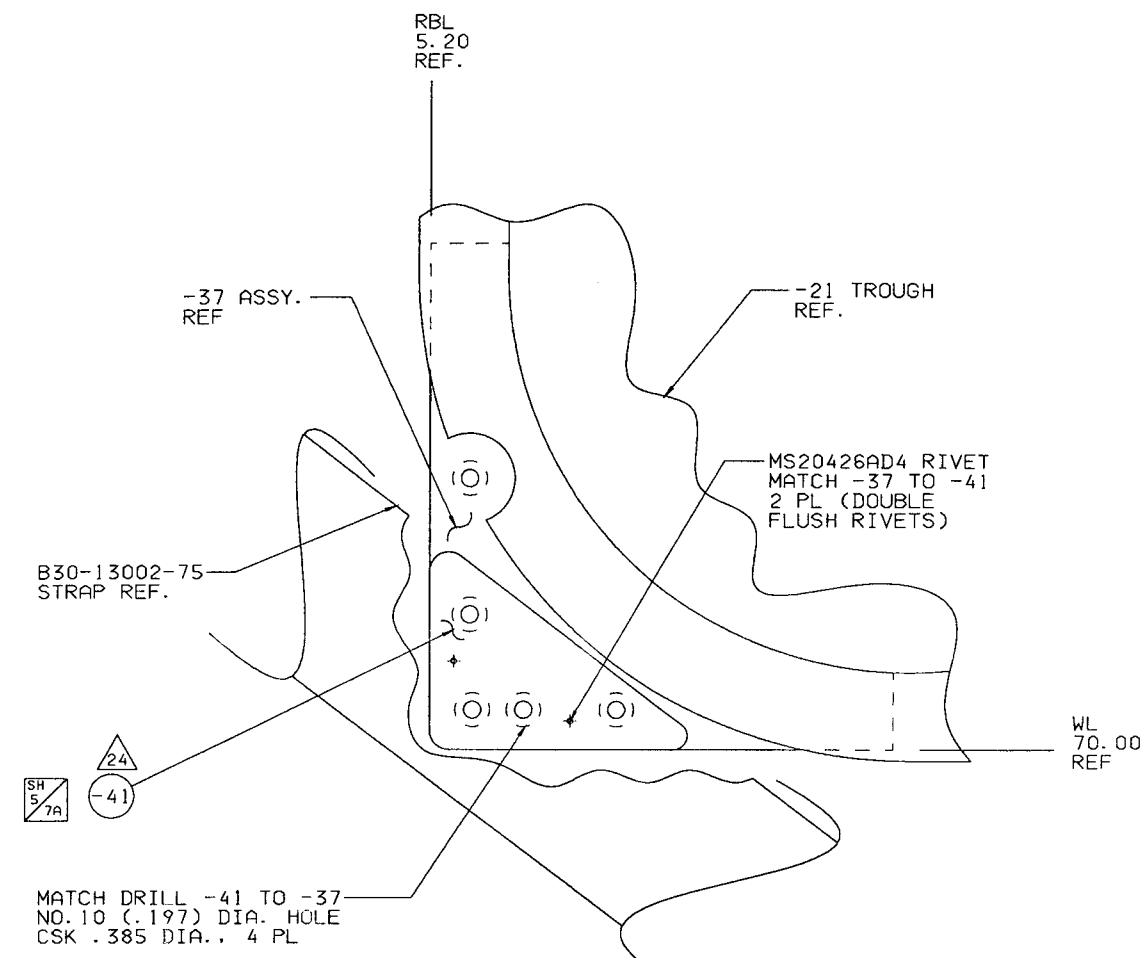
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B2313002, 02

ORIGINAL

STC SH7923SW STC SH7934SW

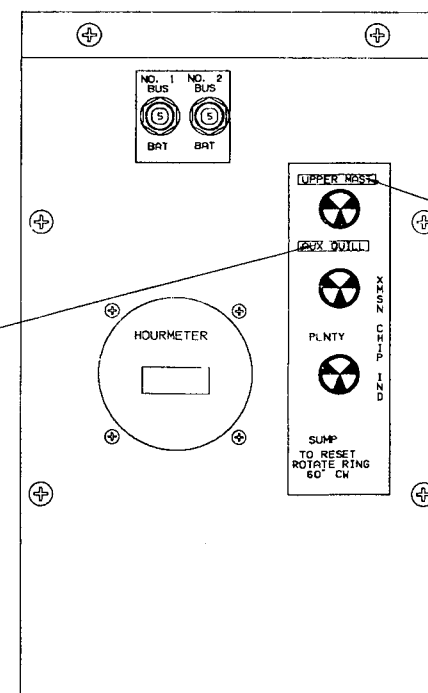
8 7 6 5 4 3 2 1



VIEW C-C

VIEW LKG AFT
@ STA 127.47 REF
(ALT VIEW FOR
PREMIER HOIST INSTL)

REMOVE EXISTING **MAST** LABEL TAPE
AND REPLACE WITH LABEL SHOWN
CROIX TYPE
FONT: HELVETICA
MEDIUM 12 POINT
WHITE ON CLEAR



VIEW E

VIEW LKG INBD
@ RBL 8.00 REF

STA
37.00
REF.

MS21042L6 NUT
AN960-616 WASHER
TORQUE TO 160-190 IN-LBS
2 PL. EA.

212-040-703-105 QUILL (-01)
412-040-703-103 QUILL (-39)
REF.

BL
0.00
REF.

SH 5 2C
-43

41° ± 5°

STA
130.00
REF.

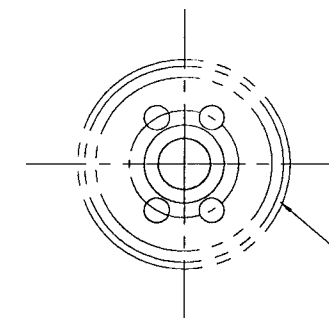
FWD

VIEW A-A

VIEW LKG DOWN
@ WL 127.47 REF

HOURMETER PANEL
REF.

REMOVE EXISTING **UPPER** LABEL TAPE
AND REPLACE WITH LABEL SHOWN
CROIX TYPE
FONT: HELVETICA
MEDIUM 12 POINT
WHITE ON CLEAR



VIEW D-D

VIEW LKG FWD
@ WL 132.00 REF.

REMOVE EXISTING HARDWARE
AND REPLACE WITH
AN6-16A BOLT
NAS43HT6-25 SPACER
212-040-199-001 WASHER
AN960-616 WASHER
MS21042L6 NUT
TORQUE TO 230-250 IN-LBS
4 PL. EA.

TRANSMISSION
REF.

205-040-114-001 BRACE

SIZE CODE IDENT NO. REV
D PSUV8 B23-13002 G

GEN/PUMP QUILL INSTALLATION

SHEET 2A OF 5

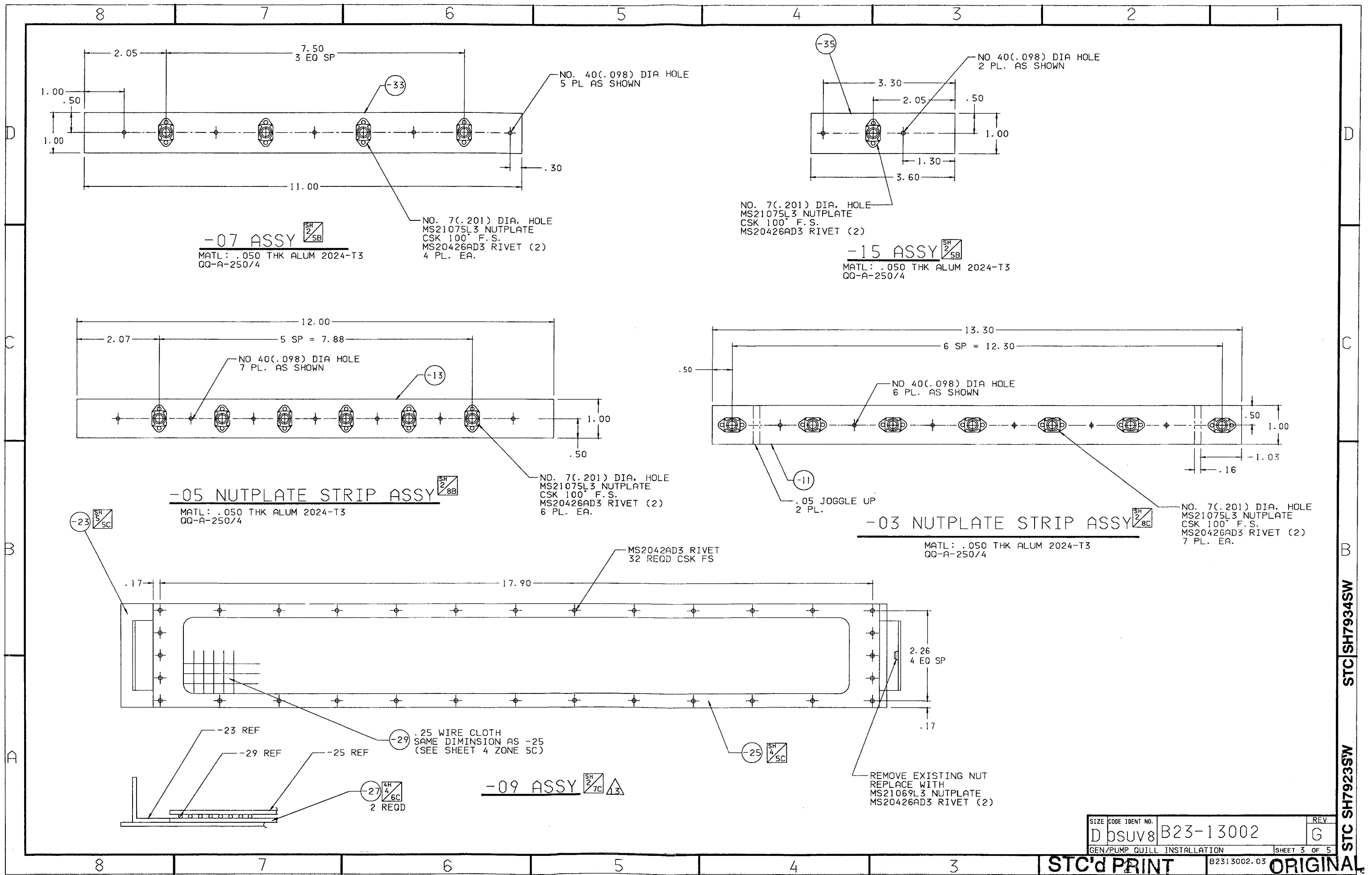
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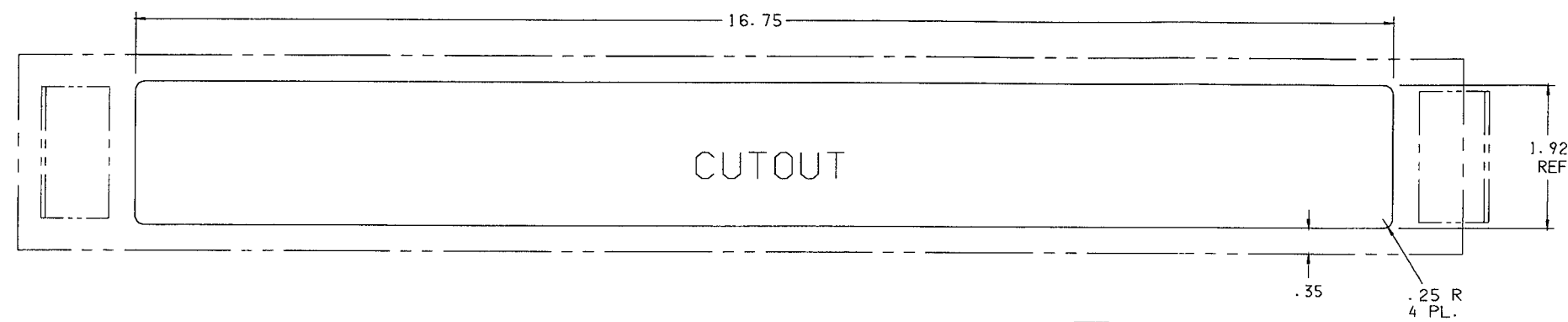
B2313002, 02A

ORIGINAL

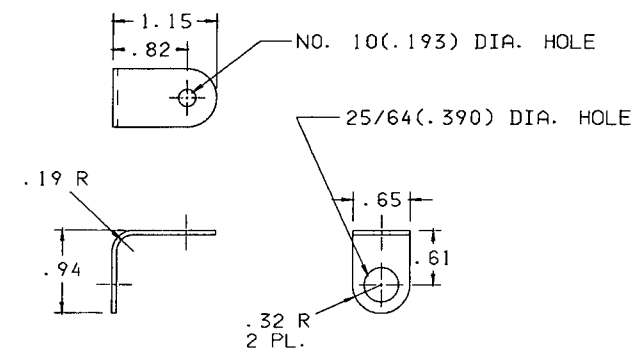
STC SH7934SW


STC SH7923SW

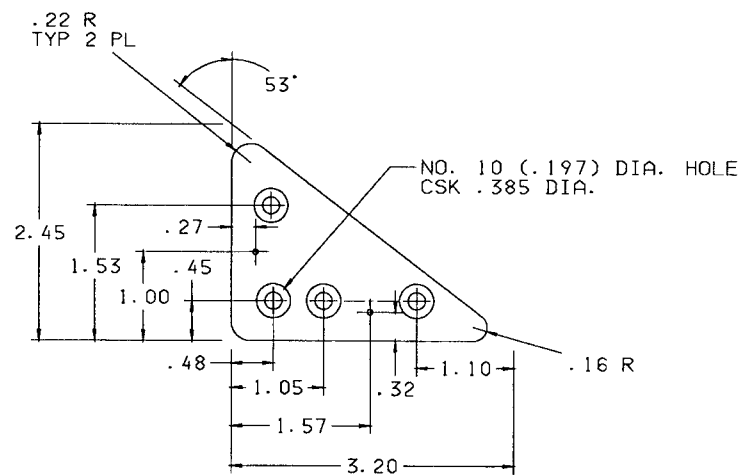






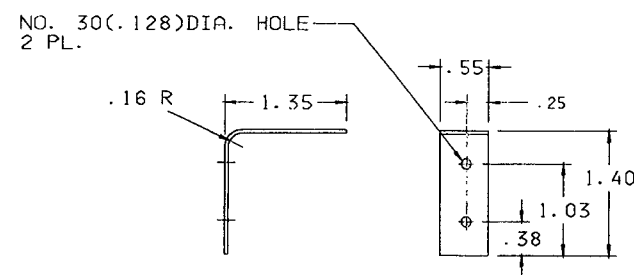
-23 MODIFICATION 
400SG125-2 (AIRCRAFT PART CORP.)




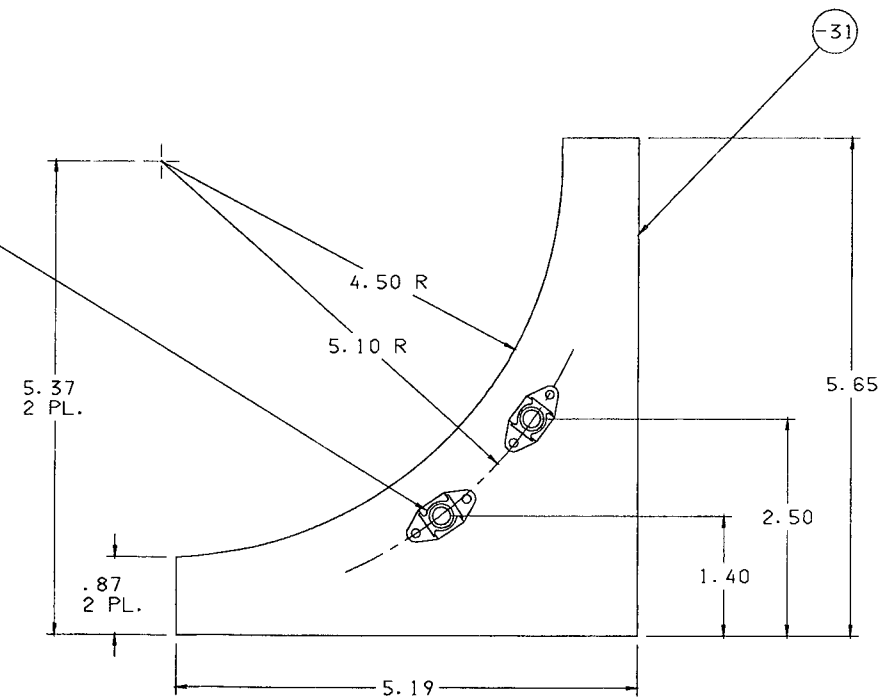
-43 BRACKET 
MAT'L.: .050 THK 2024-T3
QQ-A-250/4




-41 SPLICE  
MATL: .090 THK ALUM 2024-T3
QQ-A-250/4



-19 CLIP 
MAT'L.: .040 THK 2024-T3
QQ-A-250/4



-37 ASSY 
MAT'L.: .050 THK 2024-T3
QQ-A-250/4

SIZE	CODE	IDENT NO.	REV
D	psuv8	B23-13002	G
GEN/PUMP QUILL INSTALLATION			SHEET 5 OF 5

STC'd PRINT

B2313002.05

ORIGINAL

STC SH7923SW
STC SH7934SW